: LID PRO ARM ASSEMBLY (SHORT)

User:

Friday, 1/18/2008 9:00:17 AM

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 36849 **Estimate Number**

: 10258

P.O. Number

This Issue : 1/18/2008

Prsht Rev.

First Issue Previous Run : NC

: 1/17/2008 : 35718

S.O. No. :

Type

: SMALL /MED FAB

Part Number

Drawing Name

Drawing Number

Project Number

Drawing Revision

Material

Due Date

: 2/10/2008

: D2332041

: D2332

: N/A

: C

Qty:

20 Um:

Each

Written By

Checked & Approved By Comment

: Est: B 02.08.12

Re-format; Incorporated D2332-13/-11/-7/-5 K

J/RF

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304TR1000WO49

304 RD Tube 1.0" x .049W

Comment: Qtv.:

0.4331 f(s)/Unit Total:

8.6625 f(s)

Material: 1.000" OD x 0.049" wall SS Tube (Seamless) M 105260

Batch M 105260

2.0

M304R250

1/4" 304 SS Roundbar



Comment: Qty.:

0.1092 f(s)/Unit

Total:

2.1840 f(s)

Material: Ø0.250_304SS Rod Batch 105250

3.0

SMALL FAB

SMALL & MEDIUM FAB RESOURCE 1

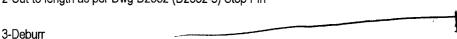






1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar

2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin



4.0

M304TR0500W035

304 RD Tube .500 x .035W



Comment: Qty.:

1.2502 f(s)/Unit

Total:

25.0040 f(s)

304 RD Tube .500 x .035W

H 106593

08-01-24 (25

Ju 08/01/31/50

Dart Ae	rospace L	td							
W /O:			WC	ORK ORDER CHANGE	ES				
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	:	PAR #:	Fault Cate	gory:				Date:	
NCR:		,	WORK ORD	ER NON-CONFORMA	NCE (NCR)			
		Description of NC	Corrective Action Section E			Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
			•						
			-						

NOTE: Date & initial all entries

Friday, 1/18/2008 9:00:17 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: LID PRO ARM ASSEMBLY (SHORT) Customer: CU-DAR001 Dart Helicopters Services Job Number: 36849 Part Number: D2332041 Job Number: Description: Seq. #: Machine Or Operation: BRAKE NC NC BRAKE Comment: NC BRAKE Punch or form to length as per Dwg D2332 (D2332-11) using DT8012 20 FF 00-01-24 (Note: Make (2) D2332-11 Prop Arms per assembly.) 6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1 Comment: LARGE FABRICATION RESOURCE 1 1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly) 2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly) 🗸 SS Rod Batch: (V 7.0 QC9 VISUAL WELDING INSPECTION Comment: VISUAL WELDING INSPECTION QC5 INSPECT WORK TO CURRENT STEP 8.0 Comment: INSPECT WORK TO CURRENT STEP SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1 9.0 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Tumble 2-Assemble as per Dwg D2332 10.0 AN44A Bolt Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s) Pick: Qty Part Number Description M10129/ 1 AN4-4A Bolt 8/2/650 20x 20

Dart Aerospace Ltd

W/O:			\N/C	DIV ODDED CHANC				
W/O:			VVC	ORK ORDER CHANG	ES			
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	*	PAR #:	Fault Cate	gory:				
					QA: N/0	C Closed:	Date: _	·
NCR:			WORK ORDI	ER NON-CONFORMA	ANCE (NCR)			
DATE	STEP	Description of NC	of NC Corrective Action		ion B	Verification	Approval	Approval
DATE		SIEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspecto
							-	
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NOTE: Date & initial all entries

Friday, 1/18/2008 9:00:17 AM Date: User: Kim Johnston **Process Sheet** Drawing Name: LID PRO ARM ASSEMBLY (SHORT) Customer: CU-DAR001 Dart Helicopters Services Part Number: D2332041 Job Number: 36849 Job Number: Description: Seq. #: Machine Or Operation: AN960JD416L 11.0 Washer 60.0000 Each(s) Comment: Qty.: 3.0000 Each(s)/Unit Total: Pick: Qty Part Number Description 3 AN960JD416L Washer 12.0 MS21042L4 Nut Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s) Pick: M105938 Qty Part Number Description MS21042L4 Nut (or -4) 20 13.0 QC5 INSPECT WORK TO CURRENT STEP WORK TO CURRENT STEP 14.0 PACKAGING 1 PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 15.0 Comment: FINAL INSPECTION/W/O RELEASE mi scool 2 Job Completion

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			:					
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Part No		PAR #: Fault Category:	NCR	: Yes	No DQ	A:	Date:	
				QA: N	N/C Close	d:	_ Date: _	

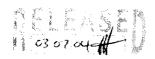
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B			Vifiti			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	
1									

NOTE: Date & initial all entries

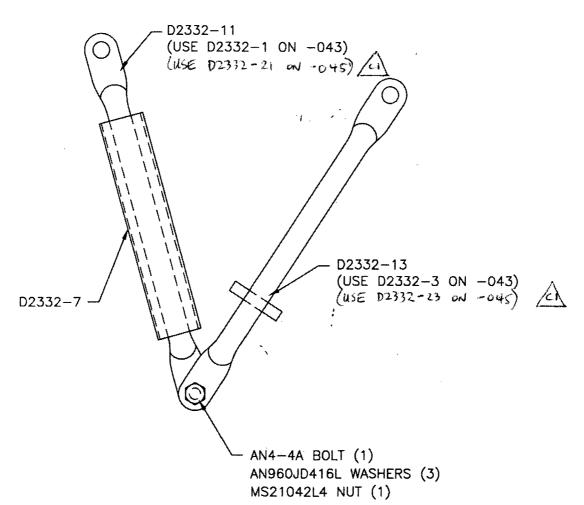




1	DESIG	#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	CHECH	(Ep)	APPROVED .	DRAWING NO. REV. 0 D2332 SHEET 1 OF 1
	DATE			TITLE SCAL
	03.0	7.03		LOD PROP ASSEMBLY NT
	Α		94.12.16	NEW ISSUE
	В		97.09.30	CHANGE 416 WASHERS TO 416L
	С		03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)



Α	94.12.16	NEW ISSUE
В	97.09.30	CHANGE 416 WASHERS TO 416L
С	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)
CI	#41 03 08.06	ADD -045 PROP (7.25" LONG)



D2332-041 SHOWN (D2332-043 SIMILAR) (D2332-045 SIMILAR) (CA

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Ŧ 6.690 DOCUMENT IS PRIVATE AND CONFIDENTIAL OR COMMUNICATED (8.000 ON -1)(7.250 av -21) 5.000 D2332-7 LOCKING COLLAR D2332-11 PROP (D2332-1 SIMILAR) 2.500 03.07.03 1.250 D2332-5 STOP PIN AEROSPACE
NOTION THAT IT IS I DRAWING N MAKE LID PROP NOT TO BE USED FOR UDART AEROSPACE LTD. DRILL 1/4 HOLE FOR D2332-5 D2332-13 M/F D2332-11 & D2332-5 (D2332-3 SIMILAR - M/F D2332-1 & D2332-5) 00 6 (DZ332-23 SIMILAR - M/F DZ332-21 4 DZ332-5) 8, 5 * PURPOSE NOTES: 1. MATERIAL: 0.5 OD \times 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035 0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250 SHEET 욹 1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049 COPIED TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13 2 OF 2